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(71) Applicant(s)

Emhart Glass Machinery Investments Inc

(Incorporated in USA - Delaware)

**RL&F Service Corp, One Rodney Square, 10th Floor,
10th and King Streets, Wilmington, Delaware 19801,
United States of America**

(72) Inventor(s)

George Kenneth Windle

John Michael Wightman

Neil James Plater

(74) Agent and/or Address for Service

Diana C Stagg

Emhart Patents Department,

Emhart International Ltd, 177 Walsall Road,

BIRMINGHAM, B42 1BP, United Kingdom

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(56) Documents Cited

DERWENT WPI 92-352913/43 & JP040254423

(58) Field of Search

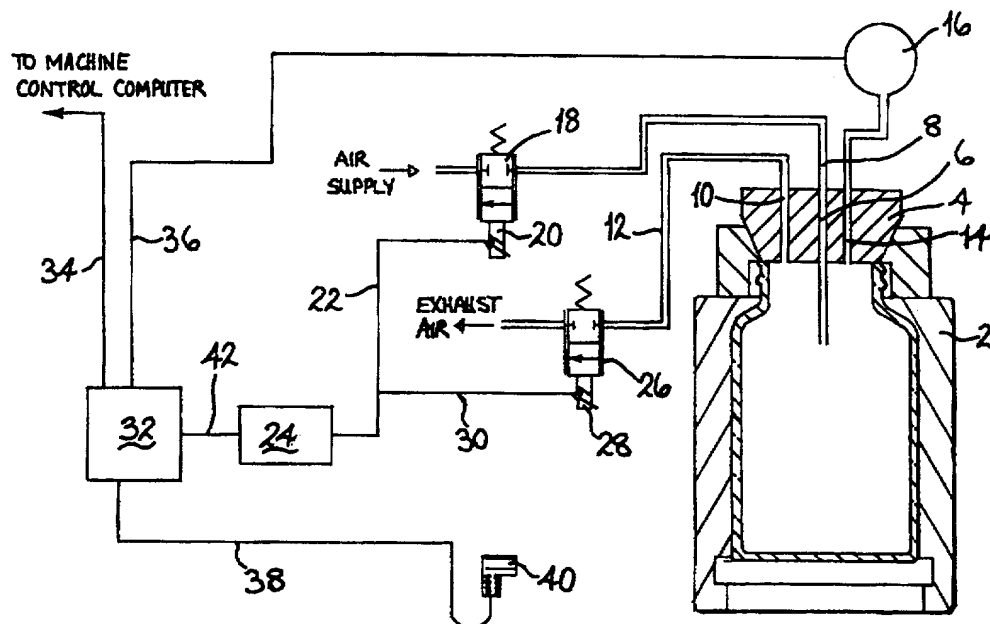
UK CL (Edition N) C1M MFT

INT CL⁶ C03B 9/36

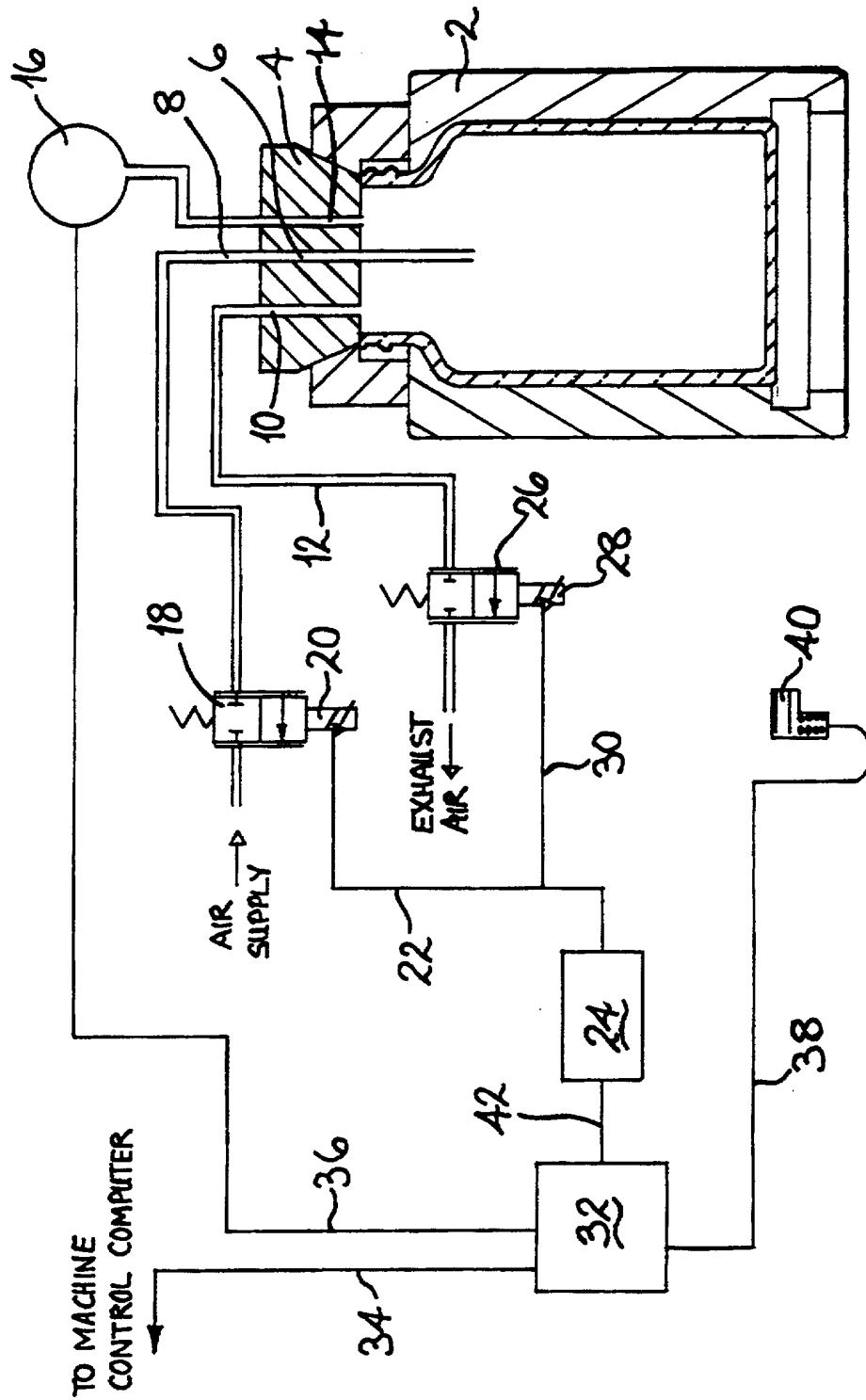
On line : WPI

(54) Controlling air supply to glassware blow mould by computer

(57) Proportional valves 18, 26 in the inlet 8 and exhaust 10 passages of blowing air supplied to a blow mould 2 of an I.S glassware manufacturing machine are controlled by a computer 32 to obtain optimum conditions of supply of air to the mould to blow a container into its final form. The computer responds to pressure signals from the pressure sensor 16 measuring the air pressure in the mould.



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This invention is concerned with the manufacture of glass hollow ware.

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A common machine for use in the manufacture of glass hollow ware in the I.S machine, which machine comprises a series of identical sections arranged alongside each other and arranged to operate slightly out of place one with
10 another so that a substantially continuous flow of formed glass hollow ware is provided.

The sequence of operations in a single section of an I.S machine is as follows:

- 15 1 A gob of glass is provided, from a feeder associated with the machine, into a parison mould
2 The glass is formed in the parison mould into a parison having its neck portion in contact with neck ring members of an invert mechanism
20 3 The parison mould opens and the formed parison is transferred by the invert mechanism to a blow station
4 Blow mould members close about the parison
5 A blow head descends to a position over the neck portion of the parison and blows air into the parison to
25 blow it into a fully formed container in the blow mould members
6 A take out mechanism engages the neck portion of the hollow container, the blow moulds open, and the take out moves the blow container to a dead plate, at which it is
30 cooled, and from which it is pushed out onto a conveyor by which it is carried to inspection and packing operation

The whole operation of forming glass in a machine of this type is dependent on utilising the peculiar qualities
35 of glass - its low conductivity and its lack of a specific

melting point - molten glass is in fact a super cooled liquid whose viscosity reduces as its temperature rises. Consequently, when a parison is formed, the outside of the parison is chilled by contact with the parison mould and 5 forms a skin which has sufficient strength to maintain the shape of the parison as it is transferred from the parison mould to the blow mould. If the parison is then held without substantial external cooling, the parison reheats, that is to say heat passes from the interior of the parison 10 to the outside of the parison so that it becomes flowable, thus permitting the parison to be successfully blown into a formed container.

When a parison is blown in the blow mould it is 15 essential that it has been able to reheat to allow a good container to be formed. At the same time, after the container has been blown it is essential that the container is cooled to a shape retaining state so that it can be removed from the blow mould by the take out mechanism 20 without risk of distortion.

The blowing operation is sometimes assisted by the application of vacuum to the blow mould, which assists in drawing the glass into contact with the inner surface of the 25 mould. Cooling of the glass is effected partly by cooling of the blow moulds and partly by the air which is blown into the mould to form it.

Consequently consistently to provide satisfactory 30 containers, that is containers which accurately conform to the mould and which are in a proper shape-retaining state when removed from the blow mould, it is necessary accurately to control the pressure, duration and amount of blown air which is supplied to the container. Normally this is set on 35

an ad hoc basis and is adjusted by the machine operator according to his experience.

It is an object of this invention to provide an
5 effective means for controlling the pressure, amount and duration of the air supplied to blow a container in the blow mould of an I.S glassware forming machine.

The present invention provides an arrangement for
10 controlling the supply of air to a blow mould in a glassware forming machine to blow a parison into a container comprising

- a blow head adapted to engage the blow mould
- a first passage in the blow head connected to a first
15 pipe for the supply of air to the blow mould
- a second passage in the blow head connected to a second pipe for the exhaust of air from the blow mould
- means for sensing the pressure of the air in the blow mould
- 20 a first proportional valve in the first pipe
- a second proportional valve in the second pipe
- a valve controller adapted to control the two proportional valves
- a computer arranged to receive
25 (i) timing signals from a machine control computer
- (ii) pressure signals from the pressure sensor means
- and
- (iii) input from a hand held terminal
- to send command signals to the valve controller to provide
30 for the desired operation of the two proportional valves

Figure 1 shows, diagrammatically, a blow mould of an
I.S glassware forming machine and means for supplying
35 blowing air to the blow mould.

A blow mould 2 is of conventional construction, and is mounted in a conventional mould opening and closing device (not shown). Mould cooling means (which may conveniently be 5 of the axial type described in EP 102, 820) is also provided.

A blow head 4 is mounted to be positioned at an appropriate stage in the operation of the machine, over the 10 blow mould 2 and is adapted to engage the blow mould. Three passages are provided in the blow head 4, a first passage 6 which is connected to a first pipe 8 for the supply of air to the blow mould from an air supply, a second passage 10 which is connected to a second pipe 12 which leads to 15 exhaust and a third passage 14 which leads to a pressure sensor 16 for sensing the pressure of air in the blow mould 2.

A first proportional valve 18 is positioned in the pipe 20 8 between the air supply and the passage 6. It is operated by a solenoid 20 which is connected through a lead 22 to a valve controller 24.

A second proportional valve 26 is positioned in the 25 pipe 12 between the passage 10 and the exhaust: the valve 26 is operated by a solenoid 28 which is connected through a lead 30 to the valve controller 24.

A digital computer 32 is connected by a lead 34 to a 30 machine control computer from which it receives timing signals, by a lead 36 to the pressure sensor 16 from which it receives pressure signals, and by a lead 38 to a hand held terminal 40 from which it receives operator input. A lead 42 from the computer 32 to the valve controller 24

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provides command signals to the valve controller to provide for the desired operation of the two proportional valves.

The arrangement for the supply of blowing air to the mould just described operates as follows. Timing and pressure information is automatically fed to the computer 32 through the leads 34 and 36. The operator feeds information, on an empirical basis, from the hand held terminal 40 through the lead 38 to the computer 32. On the basis of this information the computer calculates the desired timing and state of the two proportional valves 18 and 26 to give the desired blowing and cooling effect in the mould 2, and sends the appropriate command signals to the valve controller which transmits them to the valves. When a new container is being formed in the machine, the operator may have to adjust the settings of the hand held terminal to obtain the optimum conditions. However, once the settings for the optimum condition for a container of a particular size and weight have been determined, they may be recorded in the memory of the computer and utilised on future occasions where the same container is being manufactured.

The arrangement can be modified if desired. A less accurate control of the air can be obtained if only one of the proportional valves is used - preferably the valve 20 controlling the air supply. Further information can be supplied to the computer 32 - for example the temperatures of the inlet and exhausted air may be determined and factored into the control algorithm.

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Use of the arrangement facilitates the consistent manufacture of satisfactory containers.

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CLAIMS

1 An arrangement for controlling the supply of air to a
blow mould in a glassware forming machine to blow a parison
5 into a container comprising
a blow head adapted to engage the blow mould
a first passage in the blow head connected to a first
pipe for the supply of air to the blow mould
a second passage in the blow head connected to a second
10 pipe for the exhaust of air from the blow mould
means for sensing the pressure of the air in the blow
mould
a first proportional valve in the first pipe
a second proportional valve in the second pipe
15 a valve controller adapted to control the two
proportional valves
a computer arranged to receive
(i) timing signals from a machine control computer
(ii) pressure signals from the pressure sensor means
20 and
(iii) input from a hand held terminal
to send command signals to the valve controller to provide
for the desired operation of the two proportional
valves

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Patents Act 1977**Examiner's report to the Comptroller under Section 17
(The Search report)**Application number
GB 9501228.2**Relevant Technical Fields**

(i) UK Cl (Ed.N) C1M (MFT)

(ii) Int Cl (Ed.6) C03B 9/36

Search Examiner
C A CLARKEDate of completion of Search
8 MARCH 1995**Databases (see below)**

(i) UK Patent Office collections of GB, EP, WO and US patent specifications.

(ii) ONLINE: WPI

Documents considered relevant
following a search in respect of
Claims :-
1**Categories of documents**

- X: Document indicating lack of novelty or of inventive step. P: Document published on or after the declared priority date but before the filing date of the present application.
- Y: Document indicating lack of inventive step if combined with one or more other documents of the same category. E: Patent document published on or after, but with priority date earlier than, the filing date of the present application.
- A: Document indicating technological background and/or state of the art. &: Member of the same patent family; corresponding document.

Category	Identity of document and relevant passages	Relevant to claim(s)
A	DERWENT WPI 92-352913/43 & JP 040254423 (NIPPON ELECTRIC GLASS)	

Databases: The UK Patent Office database comprises classified collections of GB, EP, WO and US patent specifications as outlined periodically in the Official Journal (Patents). The on-line databases considered for search are also listed periodically in the Official Journal (Patents).